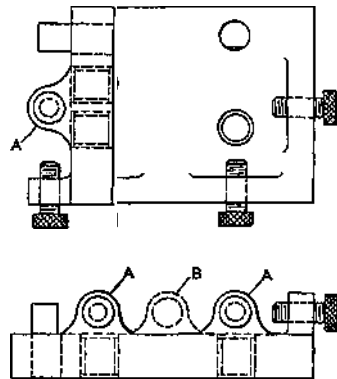


## OPEN DRILL JIGS

When using a simple jig, made as outlined in Figs. 2 and 3, this jig is simply laid down flat on the work and held against it by a C-clamp, a wooden clamp, or, if convenient, held right on the drill-press table by means of a strap or clamp, as shown in Fig. 4. Here two pieces of the work are shown beneath the jig-plate, both being drilled at one time.

Improving the Simple Form of Jig. — The first improvement that could be made on the jig shown in Fig. 3 would be the placing of locating points in the jig-plate in the form of pins, as shown in Fig. 5, in which the dotted lines represent the outline of the work. The plate need not necessarily have the shape shown in



**Fig. 7. Simple Jig with Locating Screws  
Holding the Work in Place**

Fig. 5, but may have the appearance shown in Fig. 6, according to the conditions.

The adding of the locating points will, of course, increase the cost of the jig, but the amount of time saved in using the jig will undoubtedly make up for the added expense of the jig, provided a fair number of pieces is to be drilled; besides a great advantage is gained in that the holes will always be located in the same relation to the two sides resting against the locating pins on all the pieces drilled. The locating pins are flattened off to a depth of  $\frac{1}{16}$  inch from the outside circumference, and dimensions should be given from the flat to the center of the pin